

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016259**Date Inspected:** 12-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qian.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Subassembly, Bay 04, 13CW, Deck panel to U-rib.

FCAW Repair welding of partial penetration weld joints DP3150-001-003, 006; located on subassembly, Bay 04, 13CW. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Yang Bai Qian. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR.

Y-Locations for the repairs were;

W003 – 650mm.

W006 – 650, 1850, 3050mm.

Subassembly, Bay 09, 14E, Continuity Stiffener inside U-Rib.

FCAW welding of weld partial penetration joint DP3164-001-246, 245; located on subassembly, Bay 09, 14E. Welder is identified as 059464; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133. The attached photographs provide additional detail.

Subassembly, Bay 09, 14E, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3164-001-247, 244; located on subassembly, Bay 09,

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14E. Welder is identified as 059464; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Subassembly, Bay 09, 14E, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3160-001-094, 091; located on subassembly, Bay 09, 14E. Welder is identified as 201840; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Subassembly, Bay 09, 14E, Continuity Stiffener inside U-Rib.

FCAW welding of weld complete penetration joint DP3160-001-240, 243; located on subassembly, Bay 09, 14E. Welder is identified as 059421; ZPMC Quality Control Inspector (QC) is identified as Chen Shigang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Subassembly, Bay 01, Traveler Rails.

QA received ZPMC inspection notification sheet 06391 to perform dimensional inspection of traveler rails identified as 10TR2-001. The inspection was performed along with Caltrans (CT) QA Mr. Amit Juvekar, Dimensional inspections performed on each of these traveler rails include, but is not limited to, overall length, Thickness at Typical Section, Flange Width, Depth Typical Section, flange Curl at Typical Section, Web to Flange Offset The results of the inspection were recorded on Caltrans (CT) QA form "OBG DCP Hand Measurements Survey: Traveler Rails and submitted to CT QA lead for review.

This QA Inspector carried out NDE on following

Subassembly, Bay 02, Floor Beam welds.

This QA inspector performs Random Visual Testing (VT) & random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 06381). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as FB3231-001-064, 070, 076, 082, 088, 094, 100, 106, 041, 042, 045 to 050, 056 to 059, 024 to 035, 004 to 009, 011 to 014, 021 to 023, 036 to 040, 043, 044, 060 to 063, 065, 071, 077, 083, 089, 095, 101, 107, 055.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
